

Work Order ID 73913

Monday, September 19, 2011 10:07:22 AM



Page 1

Item ID: D3822-7KGY

Accept



Setup Start



Revision ID:

Stop



Item Name: Vertical Tunnel, Lower-Grey

Start Date: 9/19/2011 Start Qty: 2.00



Cust Item ID:

Required Date: 9/23/2011 Req'd Qty: 2.00



Customer:

Reference:

Approvals: Process Plan: MF Date: 11-09-19 Tooling: _____ Date: _____
QC: _____ Date: _____ SPC (Y/N): _____ Date: _____

Run Start



Stop



Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
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Draw Nbr	Revision Nbr
D3822-7	Rev. C

100 0.00



HandThermo

Memo

Hand Finishing Thermoforming

1-Cut Sheet to required Blank size

x2

DK
11/12/21

105 0.00



HandThermo

Dry Material

Memo

Hand Finishing Thermoforming

Dry Sheet as per QSI022 KYDEX

Temp: 150°F

Time IN: 4:00 pm 11/12/20

Time OUT: 2:00 am 11/12/21

x2

DK
11/12/21

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Work Order ID 73913

Monday, September 19, 2011 10:07:22 AM



Page 2

Item ID: D3822-7KGY

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Start Date: 9/19/2011 Start Qty: 2.00



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Customer:

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Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____

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QC: _____ Date: _____ SPC (Y/N): _____ Date: _____

Stop



Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
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110



Thermoform

Thermoforming Machine

Memo

1-Machine Set-Up
2-Pre-heat Tool to required temp.
3-Thermoform as per Dwg and Folio #FTA029 using tool DT9396
Dwg Rev: C
Folio Rev: B

0.00

0.00

x2

DL
11/12/21

120



QC

Quality Control

QC2- Inspect parts off machine FAI/FAIB

0.00

Memo

Visually inspect part for proper formation and texture

0.00

x2

DL
11/12/21

130



QC

Quality Control

QC8- Inspect parts - second check

0.00

Memo

0.00

8/12/22

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

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NOTE: Date & initial all entries

[illegible]

Page 3

[illegible]

Setup Start

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Stop

[illegible]

[REDACTED]

Cust Item ID:

11-11-11

Customer:

Reference:

Run Start

[illegible]

Approvals: **Process Plan:** _____ **Date:** _____ **Tooling:** _____ **Date:** _____

Stop

[illegible]

QC: _____ Date: _____ SPC (Y/N): _____ Date: _____

Date:

**Insp.
Stamp**

0.00

HandThermo

Memo

0.00

Hand Finishing Thermoforming

1-Trim to finished dimensions as per Dwg

11/12/22

0.00

[illegible]

QC

Memo

0.00

Quality Control

Complete FAI document

~~x2~~ Sh
11/12/22

0.00

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QC

Memo

0.00

Quality Control

QC5- Inspect part completeness to step on W/O

8/11/22

2

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Work Order ID 73913

Monday, September 19, 2011 10:07:22 AM



Page 4

Item ID: D3822-7KGY

Accept



Setup Start



Revision ID:

Stop



Item Name: Vertical Tunnel, Lower-Grey

Start Date: 9/19/2011 Start Qty: 2.00



Cust Item ID:

Required Date: 9/23/2011 Req'd Qty: 2.00



Customer:

Reference:

Run Start



Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____

Stop



QC: _____ Date: _____ SPC (Y/N): _____ Date: _____

Sequence ID/
Work Center IDOperation
DescriptionSet Up/
Run Hours

Tool ID

Tool #

Plan
CodeAccept
QtyReject
QtyReject
NumberInsp.
Stamp

170

Identify as per dwg & Stock Location: 150

0.00



Packaging

Memo

0.00

Packaging

11/12/22 20

180

QC21- Final Inspection - Work Order Release

0.00



QC

Memo

0.00

Quality Control

11/12/28 2111-12-23 2

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

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NOTE: Date & initial all entries

Picklist Print

Monday, September 19, 2011 10:07:19 AM

Page 1

Work Order ID: 73913



Parent Item: D3822-7KGY



Parent Item Name: Vertical Tunnel, Lower-Grey

Start Date: 9/19/2011

Required Date: 9/23/2011

Start Qty: 2.00

Required Qty: 2.00

Comments: IPP RevA: New issue DD verified by:EC
Add Step 105 Dry Material 10/04/21 DL

Ipp Rev. B

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
MKYD6185S.080-P3- 52068		Purchased		No		100	sf	436.3796	2.16	4.322161			



Kydex steel grey



Location

Loc Qty

Loc Code

therm

436.3796282

436.379628

~~1118072~~
119476

4.322161 sg fl

10/12/22

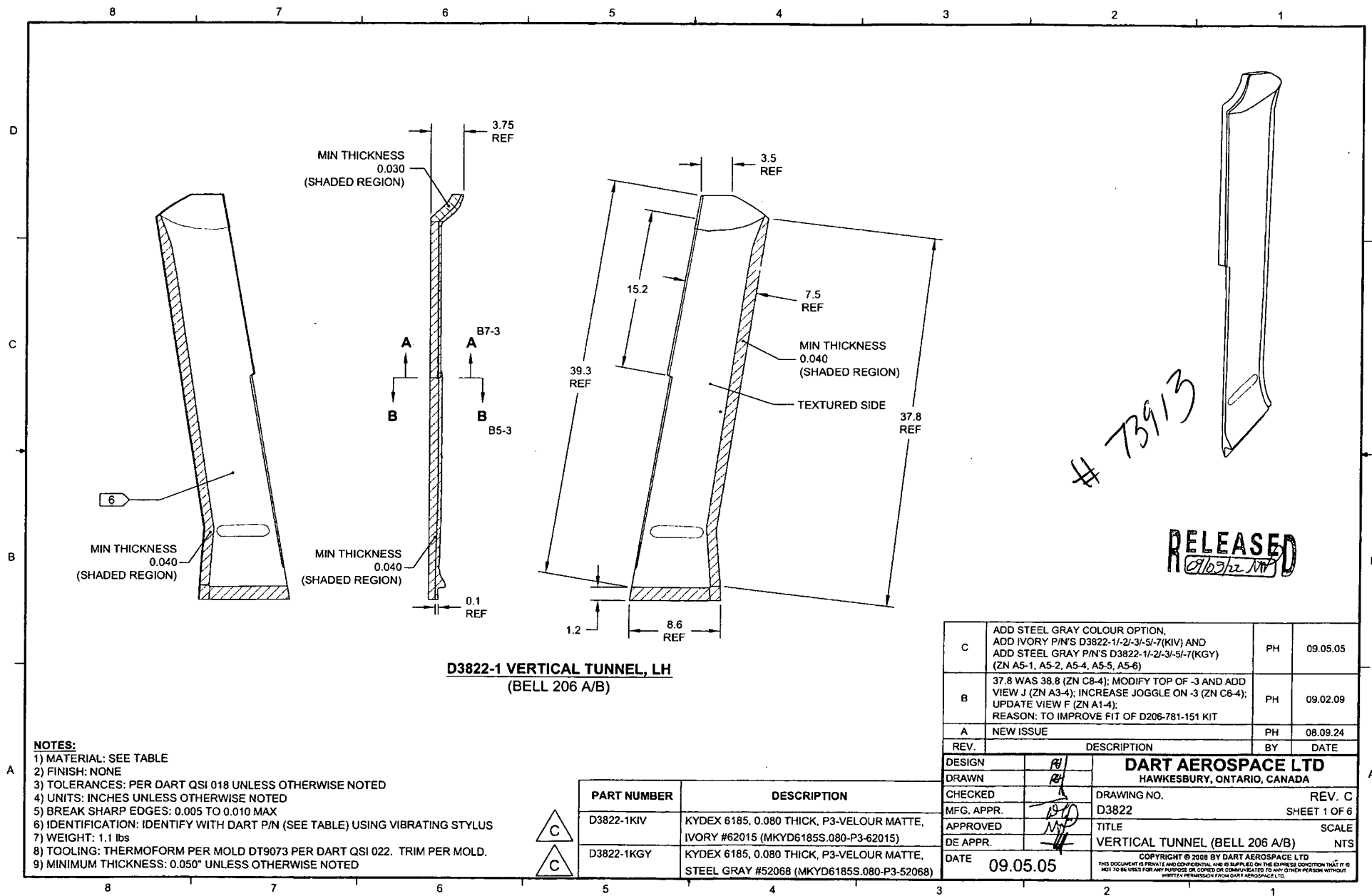
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DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

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NOTE: Date & initial all entries



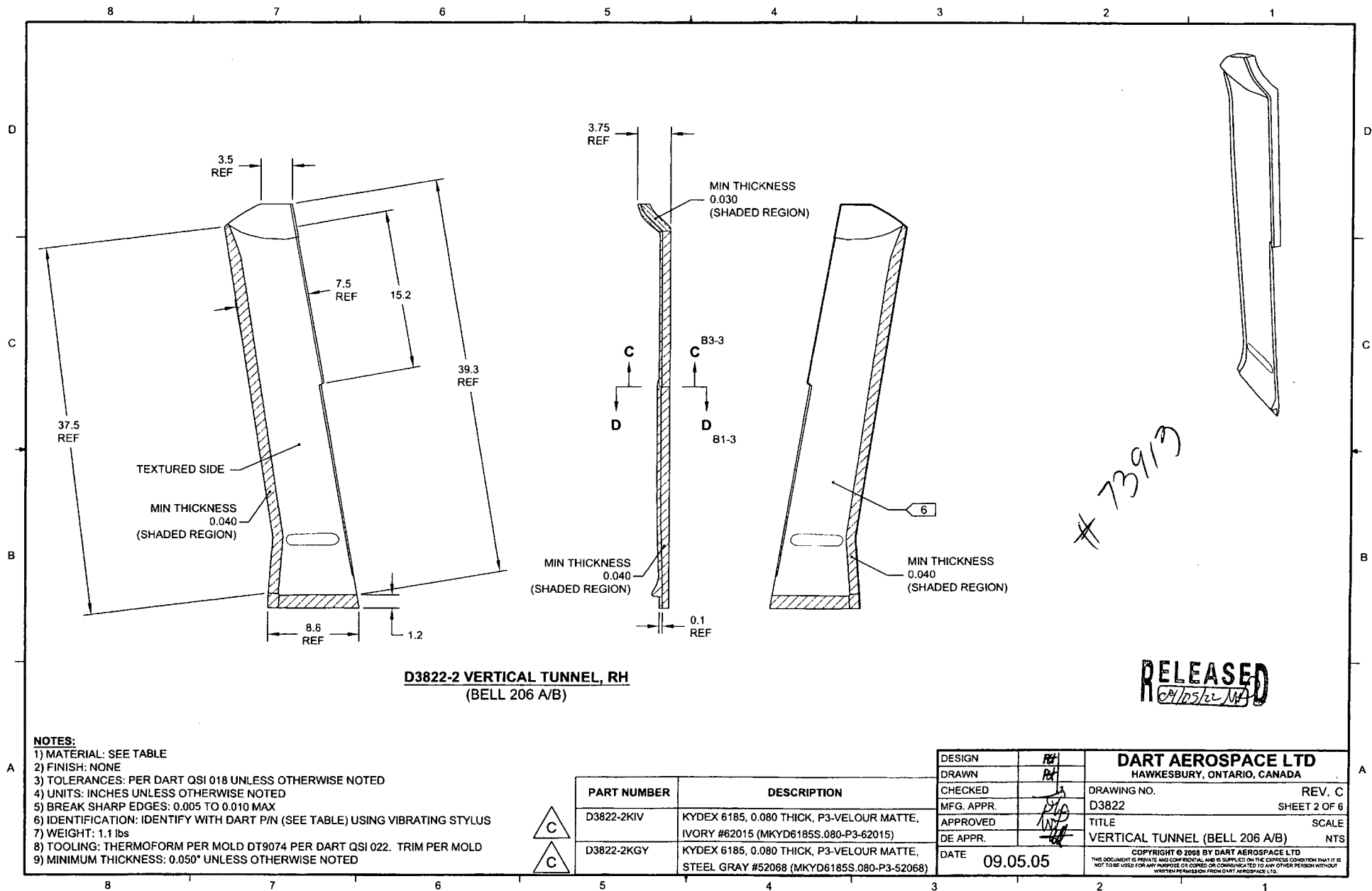
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DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

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			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries



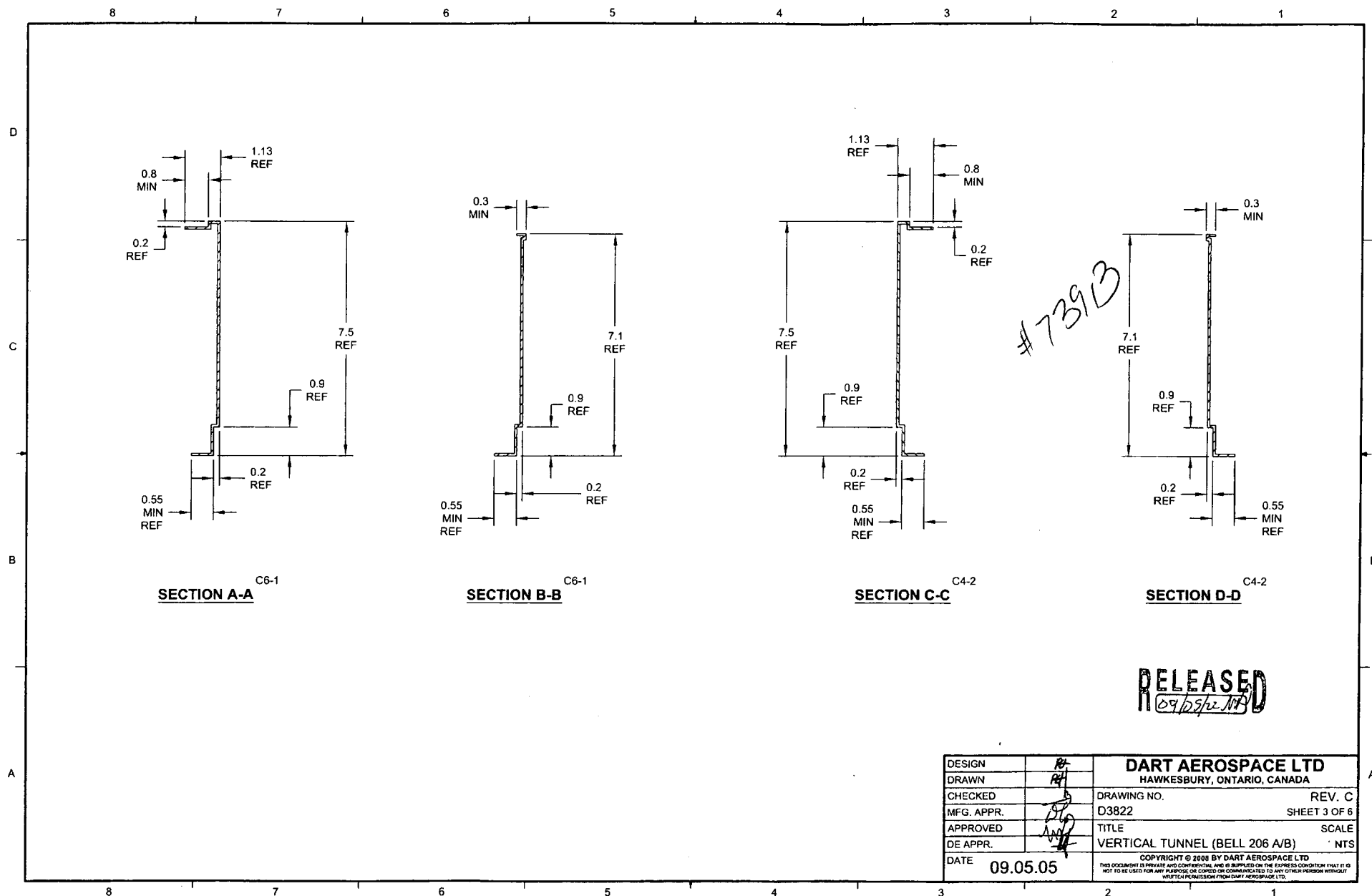
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DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

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W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

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DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

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D

C

B

B

37.8
REF

0.3
REF

MIN THICKNESS
0.035
(SHADED REGION,
BOTH SIDES)

2.4
REF

VIEW F
A1-4

VIEW J
A3-4

6.7
REF

MIN THICKNESS
0.020
(SHADED REGION)

0.5
MIN

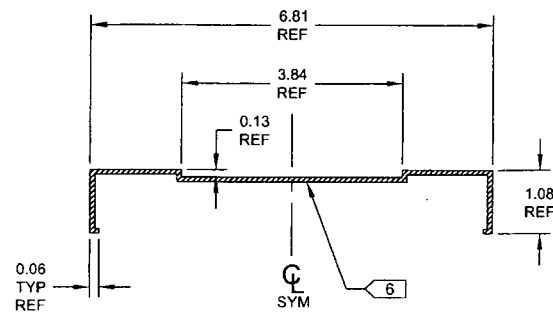
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E C2-4

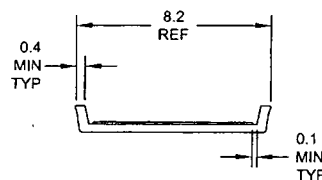
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SECTION E-E
SCALE 5X

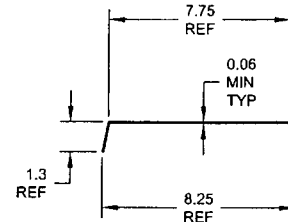
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D5-4

VIEW J
SCALE 2X

RELEASED
09/05/22 MTD



B7-4

VIEW F
SCALE 2X
(ROTATED 90° CW)

D3822-3 VERTICAL TUNNEL, AFT CENTER
(BELL 206 A/B)

NOTES:

- 1) MATERIAL: SEE TABLE
- 2) FINISH: NONE
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
- 6) IDENTIFICATION: IDENTIFY WITH DART P/N (SEE TABLE) USING VIBRATING STYLUS
- 7) WEIGHT: 1.1 lbs
- 8) TOOLING: THERMOFORM PER MOLD DT9072 PER DART QSI 022. TRIM PER MOLD
- 9) MINIMUM THICKNESS: 0.050" UNLESS OTHERWISE NOTED

C

C

PART NUMBER	DESCRIPTION
D3822-3KIV	KYDEX 6185, 0.080 THICK, P3-VELOUR MATTE, IVORY #62015 (MKYD6185S.080-P3-62015)
D3822-3KGY	KYDEX 6185, 0.080 THICK, P3-VELOUR MATTE, STEEL GRAY #52068 (MKYD6185S.080-P3-52068)

DESIGN	PA	DART AEROSPACE LTD
DRAWN	PA	HAWKESBURY, ONTARIO, CANADA
CHECKED		DRAWING NO. REV. C
MFG. APPR.		D3822 SHEET 4 OF 6
APPROVED		TITLE SCALE
DE APPR.		VERTICAL TUNNEL (BELL 206 A/B) NTS
DATE	09.05.05	

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8 7 6 5 4 3 2 1

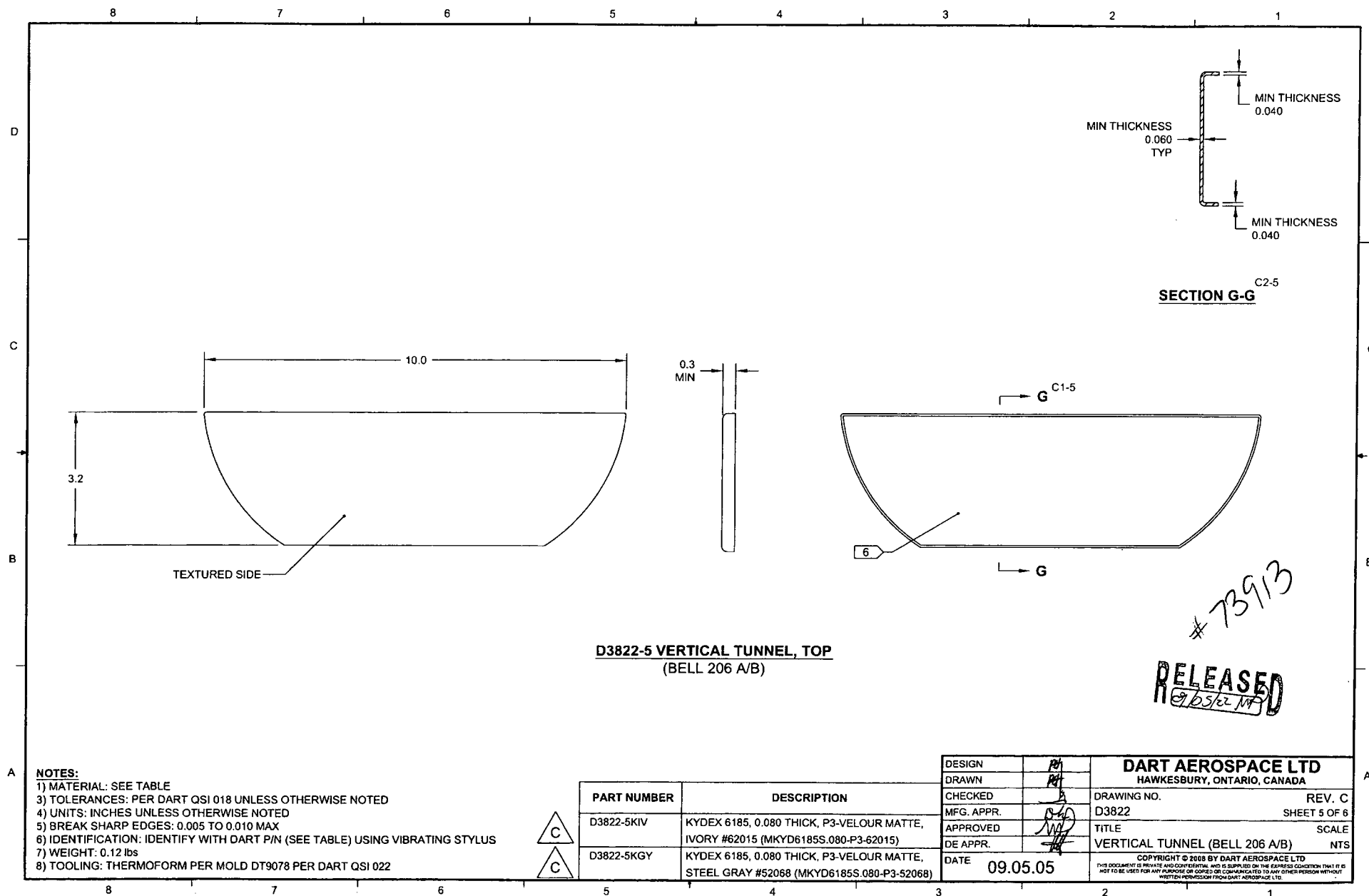
W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries



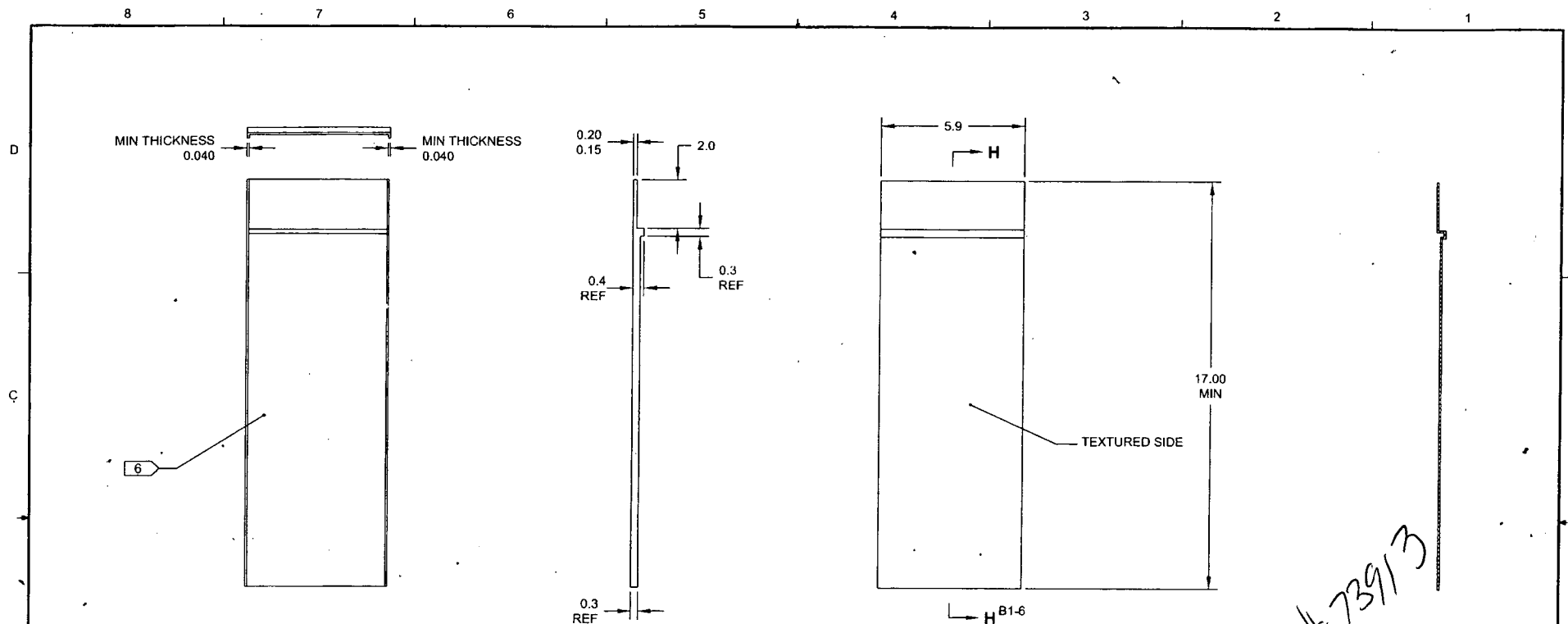
W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries



D3822-7 VERTICAL TUNNEL, LOWER
(BELL 206 A/B)

NOTES:

- 1) MATERIAL: SEE TABLE
- 2) FINISH: NONE
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
- 6) IDENTIFICATION: IDENTIFY WITH DART P/N (SEE TABLE) WITH VIBRATING STYLUS
- 7) WEIGHT: 0.36 lbs
- 8) TOOLING: THERMOFORM PER MOLD DT9396 PER DART QSI 022
- 9) MINIMUM THICKNESS: 0.060" UNLESS OTHERWISE NOTED



PART NUMBER	DESCRIPTION
D3822-7KIV	KYDEX 6185, 0.080 THICK, P3-VELOUR MATTE, IVORY #62015 (MKYD6185S.080-P3-62015)
D3822-7KGY	KYDEX 6185, 0.080 THICK, P3-VELOUR MATTE, STEEL GRAY #52068 (MKYD6185S.080-P3-52068)

DESIGN		DART AEROSPACE LTD
DRAWN	<i>PA</i>	HAWKESBURY, ONTARIO, CANADA
CHECKED	<i>PA</i>	DRAWING NO. REV. C
MFG. APPR.	<i>PA</i>	D3822 SHEET 6 OF 6
APPROVED	<i>PA</i>	TITLE SCALE
DE APPR.	<i>PA</i>	VERTICAL TUNNEL (BELL 206 A/B) NTS
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RELEASED
09/05/2005

SECTION H-H B3-6

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

DART AEROSPACE LTD		Work Order: 73913
Description: Vertical Tunnel, Lower		Part Number: D3822-7KIV/KGY
Inspection Dwg: D3822	Rev: C	Page 1 of 1

FIRST ARTICLE INSPECTION CHECKLIST

☒ First Article ☐ Prototype

THERMOFORMING SECTION

Description	Accept	Reject	Method of Inspection	Comments
Inside Radii less than <u>3/16</u> "	✓			
Shape Definition	✓			
Texture Retention	✓			
Material imperfections such as bumps, cracks, voids, scratching	✓			

Measured by: Oh Date: 11/12/21

TRIMMING SECTION

Drawing Dimension	Tolerance	Actual Dimension	Accept	Reject	Method of Inspection	Comments
0.20 - 0.15	Min	0.25"	✓		Vendor	
0.060	Min	0.073"	✓		Call TH-DT.	

Measured by: Oh Date: 11/12/22
Audited by: S Date: 11/12/22
Prototype Approval: N/A Date: N/A

Rev	Date	Change	Revised by	Approved
A	09.07.29	New Issue	KJ	